



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEA62309-3
Job Sheet 191561



Part No: RBEA62309-3

Job Qty: 5 pcs

Part Name: Stiffener Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62309 Rev.S IPP Rev. A 19.02.01 New issue DP Verify DD/IPP Rev.B 19.02.28 drawing revision
DP Verify DD

Ship Via:

Bill of Materials



Container No: S170230



Part: RBEA62309-3

Job No: 191561

Serial No/Batch: S170230

Revision: T

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/07/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	5 pcs	4/18/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	5 pcs	4/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	5 pcs	4/18/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	5 pcs	4/18/19		0.00	0.00	QC 21 - SA - 21		
							QC 21 - SA - 70		

Part Op
Descriptions: 100 - Assemble as per DWG. See note 8.

DAS
40
9-89
APR 08 2019

DAS
21
9-89
APR 08 2019

GA212

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
93286A013	Aluminum Washer 0.265" ID. X 0.688" OD.	40 Ea (8 ea)	100-Small Fab - 1	5161546
97447A651	Aluminum Blind Rivets 1/4" Dia. X 1/2" Long	40 Ea (8 ea)	100-Small Fab - 1	5161541
RBEA62309-4	Stiffener	5 pcs (1 ea)	100-Small Fab - 1	5165382
RBEA62309-5	Handle	10 pcs (2 ea)	100-Small Fab - 1	5162153

Job Allocations

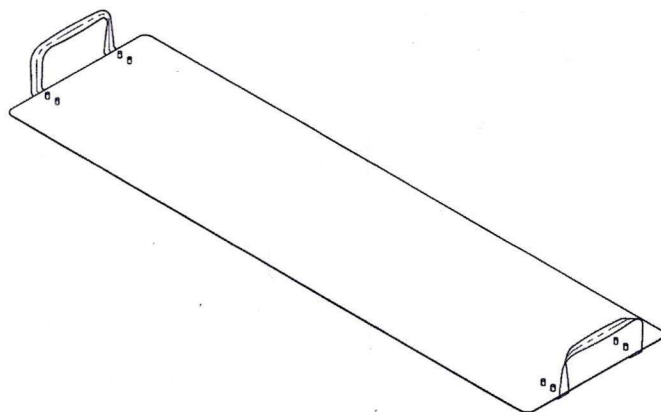
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	93286A013	40	76	0
	97447A651	40	74	0
	RBEA62309-4	5	3	0
	RBEA62309-5	10	0	0

Part Specifications

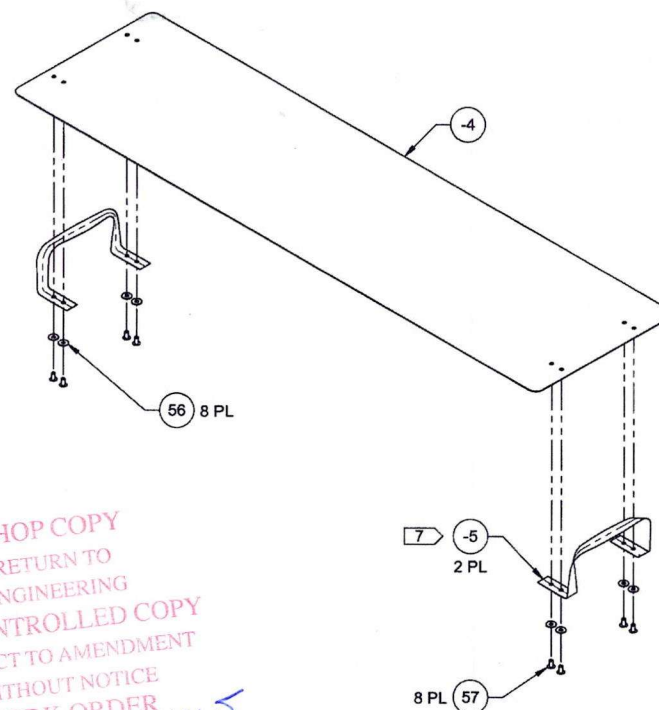
Specifications could not be found.

Plex 3/4/19 12:52 PM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-4	1	RBEA62309-4	STIFFENER
-5	2	RBEA62309-5	HANDLE
56	8	McMaster#93286A013 OR EQUIV.	ALUMINUM WASHER 0.265" ID. X 0.688" OD.
57	8	McMaster#97447A651 OR EQUIV.	ALUMINUM BLIND RIVETS 1/4" DIA. X 1/2" LG.



RBEA62309-3 STIFFENER ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191561 MWS
1403-04

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) INSTALL ITEMS -5 ONTO ITEM -4 USING ITEM 57

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. S
MFG. APPR.	DP	RBEA62309	SHEET 6 OF 12
APPROVED	W	TITLE	SCALE
DATE	2/27/2019	AS350/355 FIELD MAINTENANCE KIT	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					